

# Work Order ID 69512

Wednesday, May 11, 2011 2:19:11 PM

Page 1

Item ID: D2583

Accept

Setup Start

Revision ID:

Stop

Item Name: Latch Bracket

Start Date: 5/11/2011 Start Qty: 30.00

Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 30.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2583

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2583 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-  
Deburr if necessary

5052.040

B 11-5-12

(44)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 11-5-12

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

5052.040

Count  
(x44)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
#105/16		part scrap						

NOTE: Date & initial all entries

# Work Order ID 69512

Wednesday, May 11, 2011 2:19:12 PM



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Item ID: D2583

Accept



Setup Start



Revision ID:

Stop



Item Name: Latch Bracket

Start Date: 5/11/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 30.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC Brake NC	NC BRAKE  Memo Deburr Form on CNC Brake as per Dwg D2583	0.00  0.00				(+43)	(46)		PTD
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00							
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00							

SB 11/05/16

SB 11/05/16

count  
(+43)

43  $\phi$  M/L 11/05/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2583 PAR #: N/A Fault Category: Fab/Small NCR: Yes No DQA: 11 Date: 11.05.20  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 11/05/24 Date: 11/05/24

NCR: <u>69512</u>		WORK ORDER NON-CONFORMANCE (NCR) # <u>3.42</u>						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/05/16</u>	<u>130</u>	<u>Found 1 part with a defect</u>  <u>R.C process</u>	<u>11/05/16</u> <u>QS1042</u>	<u>Scrap &amp; destroy</u> <u>No replace</u>	<u>11/05/16</u> <u>JB</u>	<u>11/05/16</u>	<u>11/05/16</u> <u>QS1042</u>	<u>11/05/16</u>

NOTE: Date & initial all entries

# Work Order ID 69512

Wednesday, May 11, 2011 2:19:12 PM



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Item ID: D2583

Accept



Setup Start



Revision ID:

Stop



Item Name: Latch Bracket

Start Date: 5/11/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

START TIME:

3:30

OVEN TEMPERATURE:

Powder Coating

FINISH TIME:

4:00

M116964

43 M-L 11/05/16

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

43 R 11-5-17.

180

Identify as per dwg & Stock Location: 017

0.00



Packaging

Memo

0.00

Packaging

Runoff 73

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69512**

Wednesday, May 11, 2011 2:19:12 PM



Page 4

Item ID: D2583

Accept



Setup Start



Revision ID:

Stop



Item Name: Latch Bracket

Start Date: 5/11/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/18

11-05-18

(43)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, May 11, 2011 2:19:18 PM

Page 1

Work Order ID: 69512

Parent Item: D2583

Parent Item Name: Latch Bracket



Start Date: 5/11/2011

Required Date: 5/13/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP: C000.11.01 Removed P/O for Powder Coat- in house process DM  
IPP: D06.07.21 Waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M5052H32S.040

Purchased

No

100

sf

53.8000

0.1169

3.691579

5.5

-



B11-5-12

5052-H32 .040 Sheet

Location

Loc Qty

Loc Code

MAT022

53.8

117130

53.8

117130

44

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

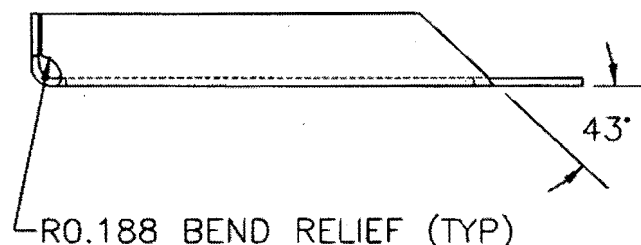
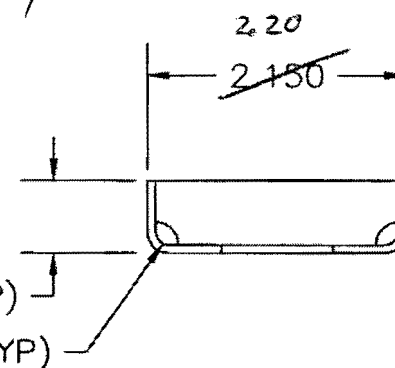
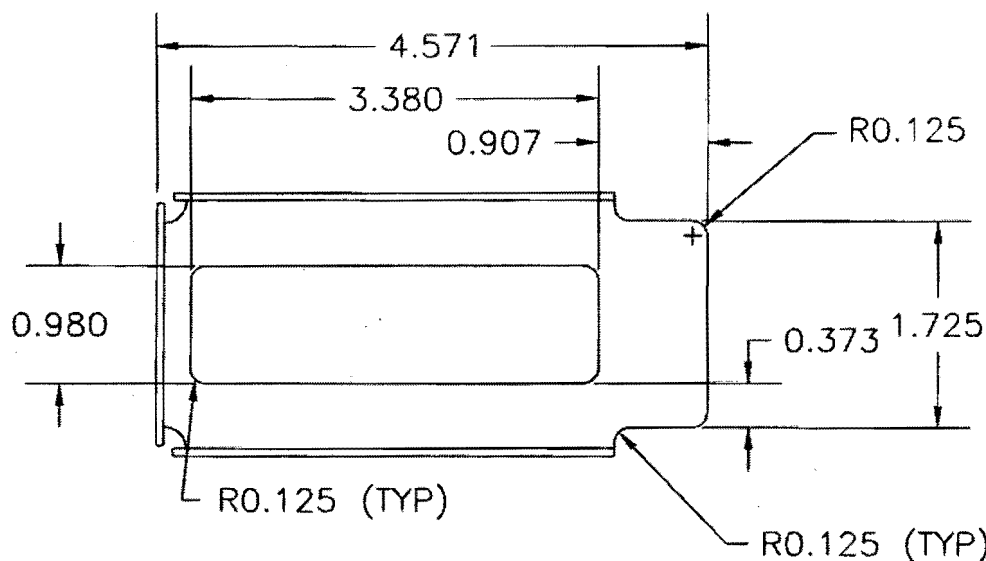
**DART**



**RELEASED**  
KE 99.02.25

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 69512

*011-05-11* *KE 99.02.26*



DESIGN	MIKE M.	DRAWN BY	RF	DART AEROSPACE LTD HAMKESBURT, ONTARIO, CANADA
CHECKED	CP	APPROVED	KE	DRAWING NO. D2583
DATE	99.02.22	TITLE	LATCH BRACKET	SHEET 1 OF 1
A	96.07.10	NEW ISSUE		SCALE 2:3
B	99.02.22	CHANGE OF FINISH (PER TSR A887)		

MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries